

Date: Tuesday, 10/3/2006 2:50:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 28830		Part Number	: D31991		
Estimate Number	: 10283		Drawing Number	: D3199 REV A1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 10/3/2006 S.O. No. : N/A		Drawing Revision	: A1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 10/30/2006 Qty: 30 Um: Each		
Previous Run	: 27384					
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:C		Removed Scribing 05-11-05 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
Comment: Qty.: 0.1040 sf(s)/Unit Total : 3.1185 sf(s) 304/316 .040" SHEET Batch: M101463 <i>M 06 10 05</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: <u>A1</u> <i>M 06 10 05</i> Prog Rev: <u>A1</u>		
Deburr if required <i>MR. 06/10/10</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>M 06 10 05</i>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>2/06/05</i>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199 <i>SB 06/10/12</i> <i>6</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Job 10-13 (30)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST413

PCP/10/20 (35)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/10/20 (38)

Job Completion



U66 powder coat grey per JS tools Q.M 06/10/20 (39)

6C Inspect level 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

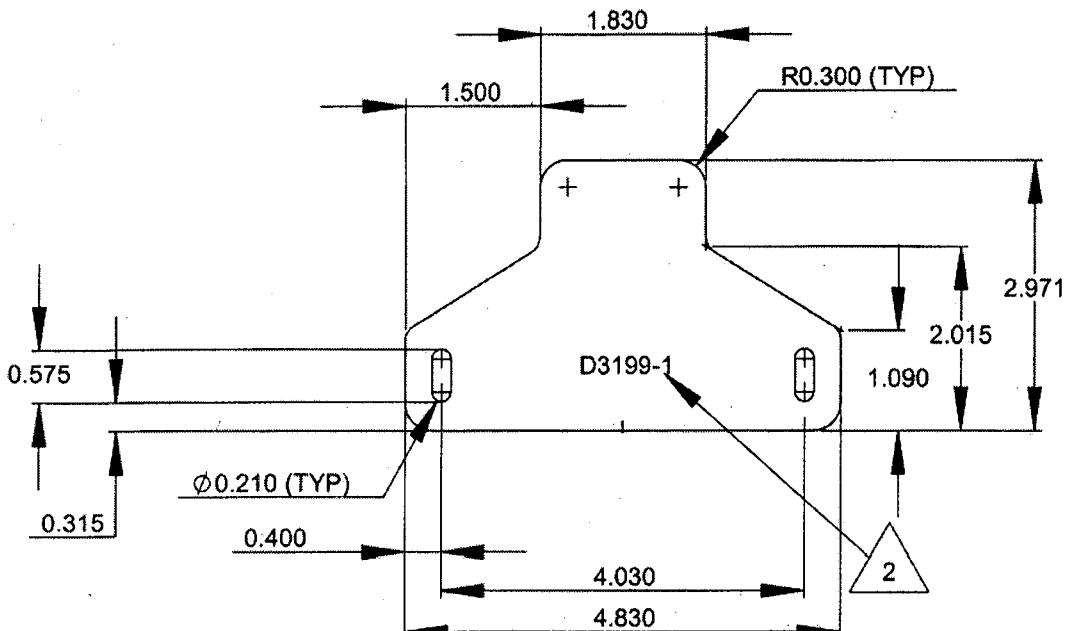
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

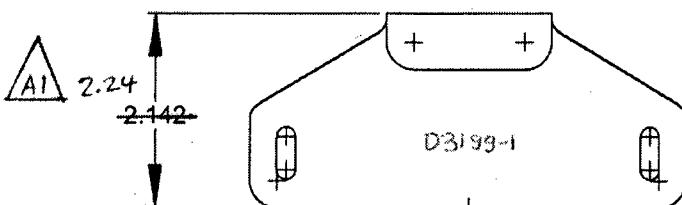


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>A</i>	APPROVED <i>CP</i>	DRAWING NO. D3199	REV. A	SHEET 1 OF 1
DATE 03.08.05		TITLE BRACKET	SCALE 1:2	
A	03.08.05	NEW ISSUE		
A1	04.03.01 <i>CP</i>	2.24 WNS 2.142		

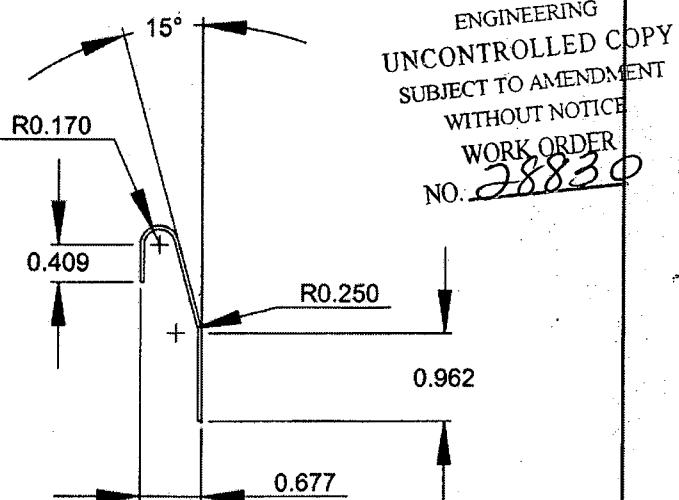
RELEASED
03.09.02 CP



D3199-1 FLAT PATTERN



D3199-1 BRACKET



NOTES

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) SCRIBE DART P/N D3199-1 AS SHOWN.
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

DART AEROSPACE LTD

Work Order: 28830

Description: Bracelet

Part Number: 3199-1

Inspection Dwg: D3199 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

8

Prototype

Measured by:

Mr. M

Audited by:

Prototype Approval:

11A

Date: 2/2/05

Date:

08-10-a

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	